



Lark Engineering Company (India) Pvt. Ltd.

I.T.I. Sasouli Road, Yamuna Nagar - 135 001 (Haryana)

Form No.	CNC/QA/FM/02
Rev. No.	01
Rev. Date	31-07-2013

Inprocess Inspection (Pellet Dies)

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		13630	55/80
2	Machined By		V.T.C. M/C Shop	Drg. No. 120.859
3	Pallet Die No.		13918(10.0)	Rev: 03
4	Die Category	Drg. No.	70mbo	
5	Out Side Diameter	Drg. No.	730mm	Step 00. 730mm / 632mm
6	Inside Diameter	Drg. No.	572.12mm	Step length 18.5mm
7	Width of Pellet Die	Drg. No.	219mm	
8	Grooves as per Drawing	Drg. No.	28x2x8mm / 67x2x8mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		M/C Shop	[Tapping W. of Hole 6]
12	Tapping PCD		650mm	
13	Tapping Hole Diameter		M16 - Check by M16 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	One Side Tapping and	Third Side One Side
15	Tapping Hole Depth		Drill Depth 40.3mm	Tapping Depth 93.5
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
Inspected By (Sign) & Date			Ravi 24/12/24	[1st 1st]
1	As per programme no.		---	[32.1mm width 19mm Deep]
2	Gun Drilling Work Completed On		---	
3	Hole Finish In Gun Drilling	Marked	ok	
4	Defective Holes (If Any)		No	
Note : Mark the defective holes/missed holes with the help of Permanent Marker			Maintain AFTER HAND	Counter: 60°
1	Counter Sinking Depth & Finish	ok		Row 27
2	External Relief Dia	11.0mm	All Rows	
3	External Relief Depth		25mm	
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Forance	
6	Material Sent For Hardening On Date		24 12 24	
Inspected By (Sign) & Date			Ravi 24/12/24	

Reviewed by (Engineer-CNC)

Manager-QA